



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-143
Job Sheet 169024



Part No: D3121-143

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/29/17

Job Tracking No:

Due Date: 12/18/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Black Tusk Helicopters Ltd (CBLAC03)

PO Box 1469, 46041 Government Road Squamish, BC, V8B 0B1 Canada ph:(604) 898-4800

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/15/17	12/15/17	0.00	0.00	Start Up Machining-1		
100	Bandsaw	4 pcs	12/15/17	12/15/17	0.00	1.47	Bandsaw1		
110	CNC Vertical Machining	4 pcs	12/16/17	12/16/17	0.41	8.51	HAAS1-3		
120	QC	4 pcs	12/16/17	12/16/17	0.00	0.00	QC2 Machining-1		
130	QC	4 pcs	12/16/17	12/16/17	0.00	0.00	QC8 Machining-1		
140	Small Fab	4 pcs	12/18/17	12/18/17	0.00	0.18	Small Fab-2		
150	QC	4 pcs	12/18/17	12/18/17	0.00	0.00	QC5		
160	Packaging	4 pcs	12/18/17	12/18/17	0.00	0.00	Packaging3-1		
170	QC21-SA	4 Ea	12/18/17	12/18/17	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.250" x 2.000") 4.425" long
Descriptions: 110 - 1-Machine D3121-113 as per Folio FA330 and Dwg D3121
140 - Assemble D3121-143 as per Dwg D3121.

M135933

\$ 018

DEC 19 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-B1.250X02.000	1	9	0	0
140-Small Fab	D3121-21 5000786	8/10	52	0	0
	D3121-241 5010570	8/10	25	0	0

Part Specifications

Specifications could not be found.

Plex 11/29/17 12:56 PM dart.lacelle.linda

DART
AEROSPACE
S019963

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Bracket Assembly

PART NO: D3121 - 143
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/11/17 Job No: 169024
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DART AEROSPACE LTD		Work Order: 169024
Description: Bracket		Part Number: D3121-113
Inspection Dwg: D3121	Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.080	✓		Kt-05	verm.
0.300	+/-0.010	0.302	✓		" "	" "
R0.375	+/-0.010	0.375	✓		R-G	—
1.54	+/-0.030	1.5485	✓		31006	H-G
0.350	+/-0.010	0.354	✓		" "	" "
R0.25	+/-0.030	0.250	✓		R-G	—
Ø0.392	+0.002/-0.000	0.3937	✓		Kt-01	micrometre.
Ø0.201	+/-0.010	0.200	✓		Kt-05	verm.
2.540	+/-0.010	2.540	✓		Kt-05	verm.
1.590	+/-0.010	1.590	✓		" "	" "
0.160	+/-0.010	0.160	✓		" "	" "
0.400	+/-0.010	0.397 0.397	✓		" "	" "
1.220	+/-0.010	1.225	✓		31006	H-G
1.600	+/-0.010	1.603	✓		Kt-05	verm.
3.80	+/-0.030	3.795	✓		" "	" "
1.800	+/-0.010	1.800	✓		" "	" "
R0.50	+/-0.030	0.500	✓		" "	" "
0.130	+/-0.010	0.130	✓		Kt-01	micro
3.41	+/-0.030	3.410	✓		31006	H-G
3.65	+/-0.030	3.65	✓		" "	" "
2.24	+/-0.030	2.240	✓		" "	" "
45°	+/-0.1°	45°	✓		CNC-17	A-G
R0.25	+/-0.030	0.250	✓		R-G	—
3.97	+/-0.030	3.967	✓		31006	H-G
R0.38	+/-0.030	0.380	✓		R-G	—
Ø0.392	+0.002/-0.000	0.3936	✓		Kt-01	micro
Ø0.201	+/-0.010	0.201	✓		Kt-05	verm.
0.268	+/-0.010	0.268	✓		" "	" "
R0.260	+/-0.010	0.260	✓		R-G	—
0.080	+/-0.010	0.080	✓		Kt-05	verm.
0.300	+/-0.010	0.297	✓		" "	" "
0.381	+/-0.010	0.382	✓		" "	" "
0.201	+/-0.010	0.201	✓		Kt-05	verm.
0.580	+/-0.010	0.582	✓		Kt-05	verm.
0.400	+/-0.010	0.400	✓		Kt-05	verm.

